

Work Order ID 53937

54456 Dorew



Page 1

November 23, 2009 2:54:21 PM

Item ID: D3391-023
Revision ID: H
Item Name: Mid Tube Assembly

Accept



Setup Start



Stop



Start Date: 23/11/2009 Start Qty: 1.00
Required Date: 02/12/2009 Req'd Qty: 1.00



Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: PL Date: 09/11/22 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3391	Rev H

100

0.00



Skidtubes

Skidtubes

Skidtubes

Memo

0.00

1-Cut tube to finish length as per Dwg D3391

2-Identify as D3391-023

3-Drill pilot holes using DT8796 (Do not drill "B" holes) and drill only 1 fwd saddle hole on one side only as per Dwg D3391

4-Open saddles and GHW holes to Ø0.375" except for fwd saddle hole of detail "J"

5-Remove .030" from Fwd indexing Ridge as per Dwg D3391

6-Remove indexing ridge on Fwd & Aft end of skidtube as per Dwg D3391

7-Deburr

8-Drill #30 pilot holes using wearplate Jig DT8217 Identify Ø0.250" holes with paint marker,

9-Open wearplate holes of D3391-023 assembly detail section G-G to Ø0.250" (14 holes) as per Dwg D3391 and 2 holes in section Detail "J", do not open wearplate holes of section "J"

10-Open wearplate holes of D3391-023 assembly detail section H-H to Ø0.297" (20 holes) as per Dwg D3391

1 11/9/11/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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November 23, 2009 2:54:21 PM

Page 2



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Run Start



Stop



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11-Open .375" holes to .438" ***do not open fwd saddle holes***

12-Locate D3391-021 in D3391-023 at 9.00" (see view z-z)

13- Transfer drill one fwd saddle hole only to .188" dia, transfer drill all remaining fwd saddle holes using DT 8149 locating from previously drill .188" dia hole, using t-pins and clicos to ensure perfect allingment, open up previously tranfer drilled pilot holes in D3391-023/-021 to 0.438" dia. in D3391-021

14- Transfer drill 2 wearplate holes into D3391-021 using DT8217, locating from two previously drilled holes, drill remaining wearplate holes into D3391-021.

15- Locating from two fwd wearplate holes drillol remaining 6 wearplte holes in D3391-021 using DT8937

16- Open 2 fwd wearplate holes in D3391-023 to .250" dia.

17- counterbore two aft wearplate holes in D3391-021 as per dwg

18- Open 12 wearplate holes in D3391-021 to 0.297" dia.

19-Deburr and blow out all chips from inside tube

8/9/11/30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval [†] Chief Eng / Prod Mgr	Approval QC Inspector

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November 23, 2009 2:54:21 PM



Page 3

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Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw/ Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	=> 5 or 10/30				f		
120 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00					1 49/11/30		
130 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							9-12-1

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November 23, 2009 2:54:21 PM



Page 4

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Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 	Skidtubes	0.00							
Skidtubes	Memo	0.00							
Skidtubes	1-Open float bag holes as per dwg 2-C'sink float bag holes as per dwg 3- Prepare tube for welding 4-Bond web in place as per Dwg D3391 & QSI 015. Adhere for 12 hours)								
150 	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									
160 	Skidtubes	0.00							
Skidtubes	Memo	0.00							
Skidtubes	1-Weld crossbolt spacer as per dwg D3391 & QSI 004 2-grind weld flush								

B 11230E
E22. 10/12/30

27 S 09/12/02

①

①

BE 09/12/04

A/R M112507

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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November 23, 2009 2:54:21 PM



Page 5

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Required Date: 02/12/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170 QC Quality Control	QC10- Inspect visual per QS1004- ground welds Memo	0.00 0.00		<i>2) 801/12/07</i>		<i>(70)</i>			
180 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		<i>2) 801/12/07</i>		<i>(70)</i>	<i>0</i>		
190 Powdercoat Powder Coating	<i>Pressure - wash</i> White Gloss(Ref:4.3.5.1) per QS1005 4.3-Alum <i>1112148</i> Memo START TIME: <i>2:30</i> OVEN TEMPERATURE: <i>820°</i> FINISH TIME: <i>3:00</i>	0.00 0.00		<i>11 09/12/07</i> <i>BR 09-12-7</i>		<i>(40)</i>	<i>0</i>		<i>11</i>

W/O:		WORK ORDER CHANGES					
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November 23, 2009 2:54:21 PM



Page 6

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Stop



Start Date: 23/11/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 02/12/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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200

QC3- Inspect Part Finish

0.00 => 48 09/12/08



QC

Memo

0.00

Quality Control

(X1)

0

210

Skidtubes

0.00 => 41 09/12/08



Skidtubes

Memo

0.00

Skidtubes

1- insert D3391-021 into D3391-23

2- insert T-pins into first and third fwd saddle holes

3- ON FIRST SIDE ONLY drill out 2nd and forth fwd saddles holes to 0.500" as per DSI 9364

4- remove T-pins and locate DT9415 from first and third crossbolt hole using T-pins and clekos

5- ON 2ND SIDE ONLY ream out 2nd and forth saddle hole to 0.499". Remove DT9415

6- deburr, re-alodine and blow out chips

7- press fit D3591-1 spacers using DT9416 starting from 0.500" side

(X1)

0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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November 23, 2009 2:54:21 PM



Page 7

Item ID:	D3391-023	Accept		Setup	Start	
Revision ID:	H				Stop	
Item Name:	Mid Tube Assembly					
Start Date:	23/11/2009	Start Qty: 1.00				
Required Date:	02/12/2009	Req'd Qty: 1.00				
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:
	QC:	Date:	SPC (Y/N):	Date:

Run	Start	
	Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		27 8 09/12/07		(46)			
230 HandFinish Hand Finishing	HandFinishing Memo Install Inserts as per Dwg	0.00 0.00		27 4 09/12/08		(X1)	Ø		
240 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		27 8 09/12/08		(40)	(Ø)		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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November 23, 2009 2:54:21 PM

Page 8

Accept

Start Date: 23/11/2009 **Start Qty:** 1.00
Required Date: 02/12/2009 **Req'd Qty:** 1.00

Cust Item ID:

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start

Stop

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

**Draw
Number**

**Draw
Rev.**

**Plan
Code**

**Accept
Qty**

Reject
QtyReject
Number

**Insp.
Stamp**

250

Identify as per dwg & Stock, Location: _____

0.00

Abstract

Packaging

Memo

0.00

Packaging

260

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

MF 09-12-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

November 23, 2009 2:54:28 PM

Page 1

Work Order ID: 53937

Parent Item: D3391-023RevH

Parent Item Name: Mid Tube Assembly




Comments:

Start Date: 23/11/2009

Required Date: 02/12/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin. Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2500-1-100RevU/R		Manufactured	No			100	Each	0.0000	1.0000			
												
Skidtube Extrusion												
D3391-021RevH		Manufactured	No			100	Each	0.0000	1.0000			
												
Fwd Tube Assembly												
D3389-1RevD		Manufactured	No			140	Each	7.0000	1.0000			
												
Web												

B 37065

B 52362

1 11/11/30

1 11/11/30

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

7

47303

1

48244

1

48245

1

48246

1

48247

1

50226

2

11/11/30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Picklist Print

November 23, 2009 2:54:28 PM

Page 2

Work Order ID: 53937



Parent Item: D3391-023RevH



Parent Item Name: Mid Tube Assembly

Start Date: 23/11/2009

Required Date: 02/12/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3681-1RevA

Manufactured

No

160

Each

83.0000

5.0000



Spacer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

LG

81

51920

20

52898

61

Main Warehouse

ST

2

47123

2

D3591-1RevB

Manufactured

No

210

Each

71.0000

2.0000



Bushing

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

71

46105

29

47121

42

47123

2Pc

BE 09/12/04

3

BE 09/12/04

x2 M 09/12/09

November 23, 2009 2:54:28 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

November 23, 2009 2:54:28 PM

Page 3

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Parent Item Name: Mid Tube Assembly

Start Date: 23/11/2009

Required Date: 02/12/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item #/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
-----------------------------	---------------------	------------	----------	------------------	---------------	--------------	-----------------	-------------	-----------------------	------------	-------------	--------

ALS4-1032-130		Purchased	No			230	Each	3,661.000	22.0000			
---------------	--	-----------	----	--	--	-----	------	-----------	---------	--	--	--



Insert

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

110511

3661

3661

1111529

x22 M 09/02/08

November 23, 2009 2:54:28 PM

Shop Packet Print

Page 3

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

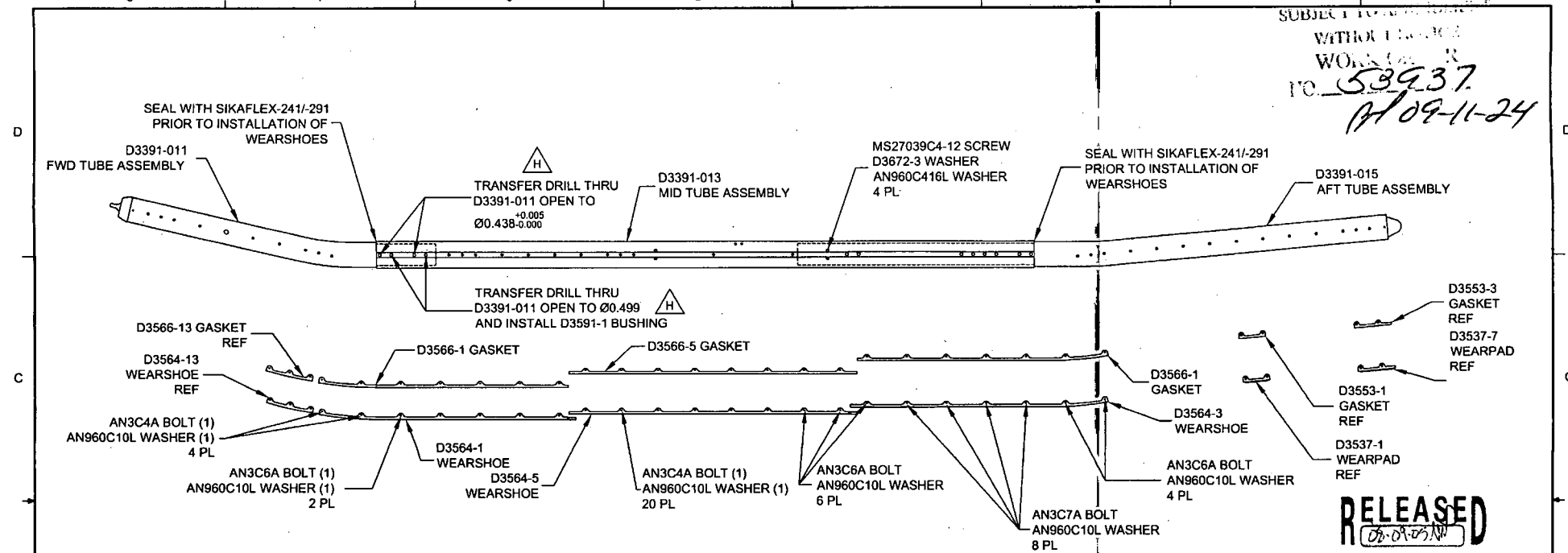
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY

SUBJECT TO THE
WITHOUT PREJUDICE
WORKING
TO 53937
11-09-11-24







D3391-041 ASSEMBLY

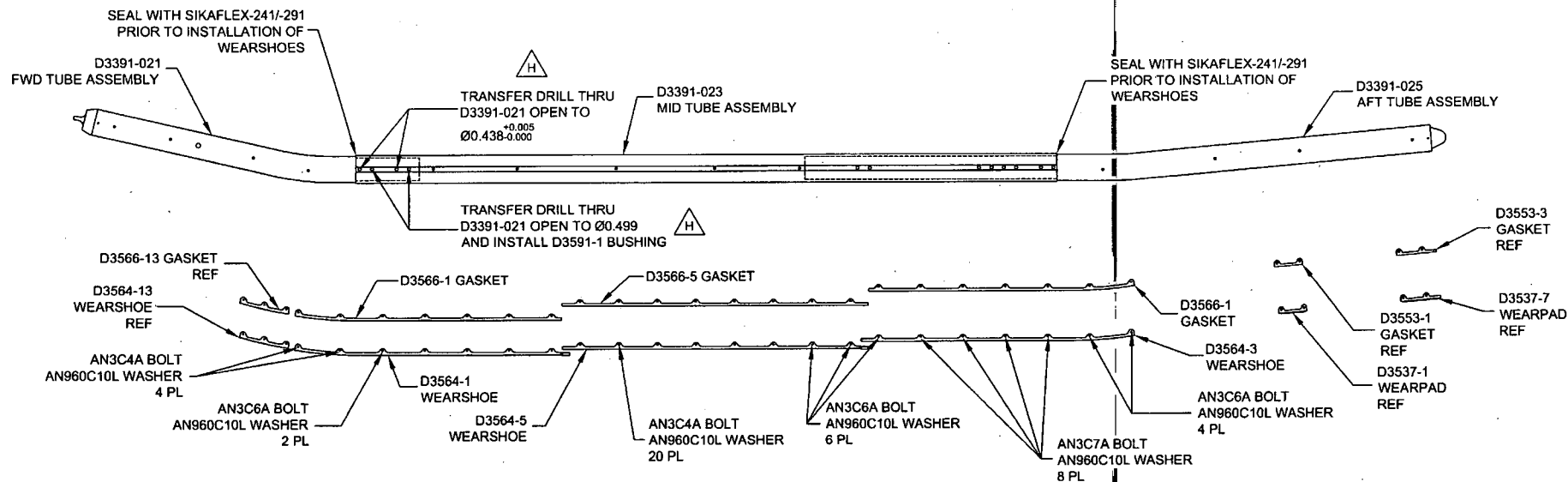
D3391-041 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
X	D3391-041	FLOAT SKIDTUBE ASSEMBLY
1	D3391-011	FWD TUBE ASSEMBLY
1	D3391-013	MID TUBE ASSEMBLY
1	D3391-015	AFT TUBE ASSEMBLY
1	D3564-1	WEARSHOE
1	D3564-3	WEARSHOE
1	D3564-5	WEARSHOE
2	D3566-1	GASKET
1	D3566-5	GASKET
2	D3591-1	BUSHING
4	D3672-3	WASHER
24	AN3C4A	BOLT
12	AN3C6A	BOLT
9	AN3C7A	BOLT
44	AN960C10L	WASHER
4	MS27039C4-12	SCREW
4	AN960C416L	WASHER

GENERAL NOTES

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL 0.297 SIZE HOLES FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED.

H	DRAWING UPDATED TO CURRENT STANDARDS. SHT 1 PL ADDED D3591-1 BUSHING. ZN C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. SHT 2 PL ADDED D3591-1 BUSHING. ZN C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. (FOR FURTHER INFO SEE DSI 9364 & NCR 08-074)	AJS	08.08.20
G	REPLACE NAS INSERTS W/ AELS INSERTS SWITCH TO D3670-XXXX SPACERS FOR INSTALLING FLOAT BAGS, DWG REORGANIZED FOR CLARITY	DC	07.07.31
F	ADD SS WEARSHOE, GASKET REMOVE FWD SADDLE HOLE -011/-021	PH	07.01.18
IE	CHANGE TOLERANCE, EASE MANUFACTURE	PH	06.04.25
ID	UPDATE TOLERANCE, CHANGE HOLE SIZE	PH	06.01.23
IC	LENGTHEN AFT EXTENSION	PH	05.09.27
IB	DRAWING UPDATES	PH	05.06.10
IA	NEW ISSUE	PH	05.02.07
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D3391	SHEET 1 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
DATE	08.08.20	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC	
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D3391-043 ASSEMBLY

D3391-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

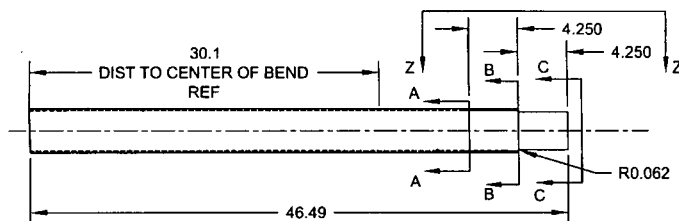
QTY	PART NUMBER	DESCRIPTION
1	D3391-043	FLOAT SKIDTUBE ASSEMBLY
1	D3391-021	FWD TUBE ASSEMBLY
1	D3391-023	MID TUBE ASSEMBLY
1	D3391-025	AFT TUBE ASSEMBLY
1	D3564-1	WEARSHOE
1	D3564-3	WEARSHOE
1	D3564-5	WEARSHOE
2	D3566-1	GASKET
1	D3566-5	GASKET
2	D3566-13	BUSHING
24	AN3C4A	BOLT
12	AN3C6A	BOLT
8	AN3C7A	BOLT
44	AN960C10L	WASHER

GENERAL NOTES

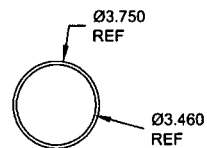
- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED.

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08-09-05-10

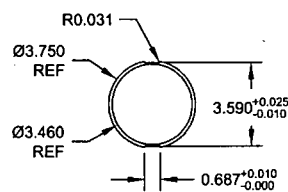
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MFG. APPR.		D3391	SHEET 2 OF 8
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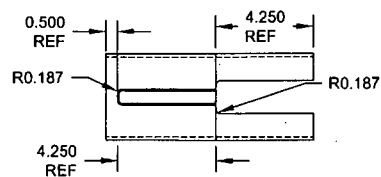
D3391-1 CUTTING DETAIL
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



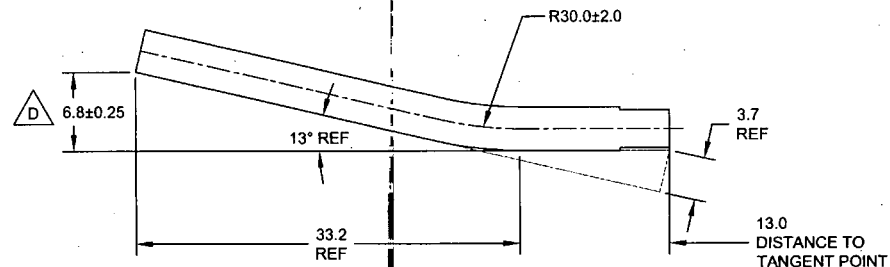
SECTION A-A
SCALE 2X



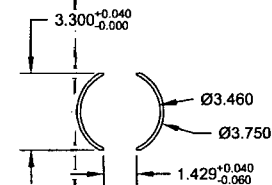
SECTION B-B
SCALE 2X



VIEW Z-Z
SCALE 2X



D3391-011/-021 BENDING DETAIL
(MAKE FROM D3391-1)

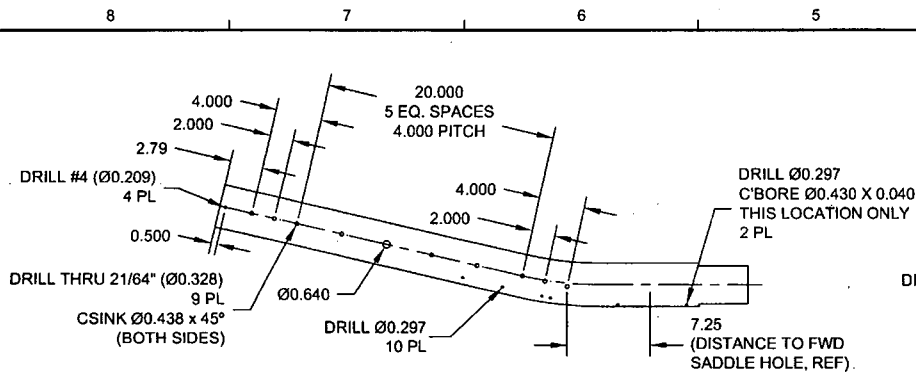


SECTION C-C
SCALE 2X

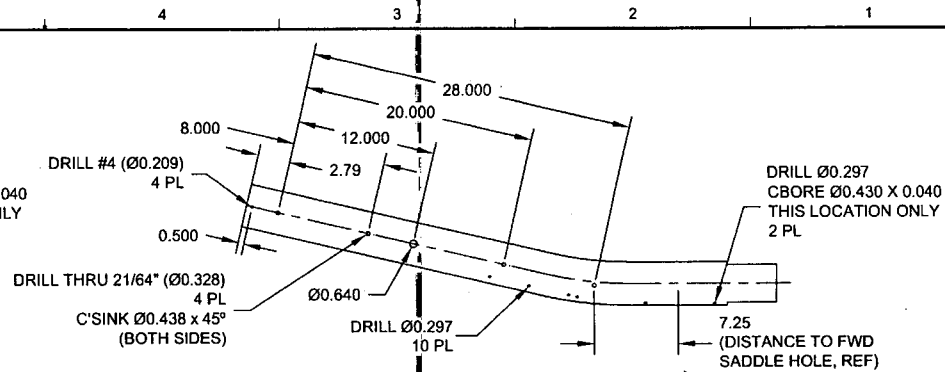
RELEASED
28 JAN 05

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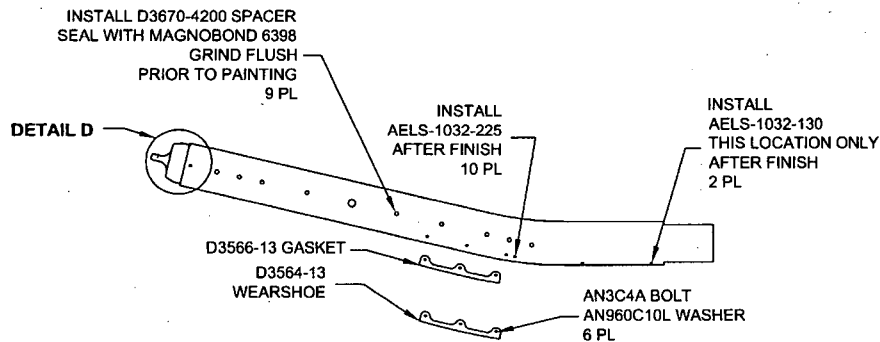
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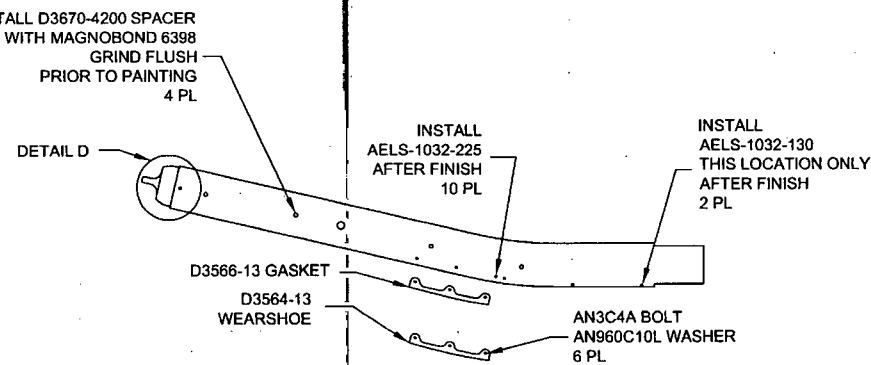
D3391-011 DRILLING DETAIL



D3391-021 DRILLING DETAIL



D3391-011 ASSEMBLY DETAIL

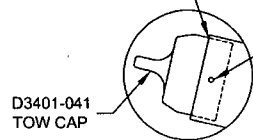


D3391-021 ASSEMBLY DETAIL

D3391-011/-021 FWD TUBE ASSEMBLY PARTS LIST

QTY - 011	QTY - 021	PART NUMBER	DESCRIPTION
X		D3391-011	FWD TUBE ASSEMBLY
	X	D3391-021	FWD TUBE ASSEMBLY
1	1	D6013-047	FWD TUBE
1	1	D3401-041	TOW CAP
1	1	D3564-13	WEARSHOE
1	1	D3566-13	GASKET
9	4	D3670-4200	SPACER
4	4	D3672-1	WASHER
10	10	AN3C4A	BOLT
10	10	AN960C10L	WASHER
2	2	AELS-1032-130	INSERT
10	10	AELS-1032-225	INSERT

SEAL WITH
SIKAFLEX-241/-291



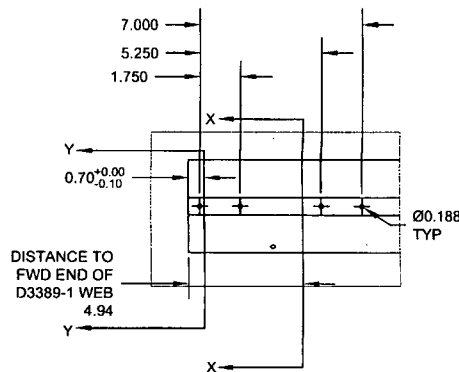
**DETAIL D
SCALE 2X**

AN3C4A BOLT
D3672-1 WASHER
AN960C10L WASHER
4 PL

RELEASED
08-07-25-14

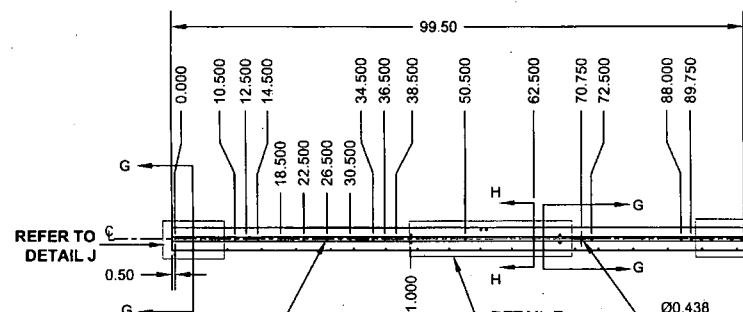
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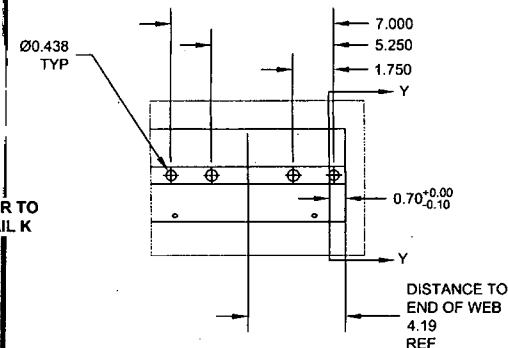
DETAIL J
SCALE 4X

DRILL THRU 21/64" (Ø0.328)
CSINK Ø0.438 X 45° (BOTH SIDES)
12 PL



D3391-013 ASSEMBLY DETAIL

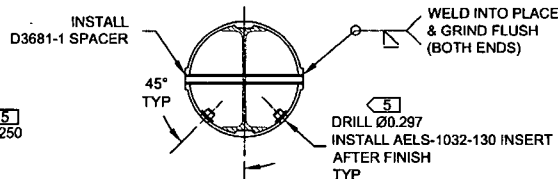
REFER TO
DETAIL K



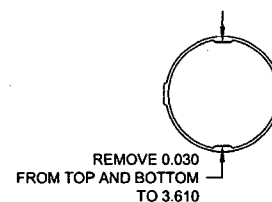
DETAIL K
SCALE 4X



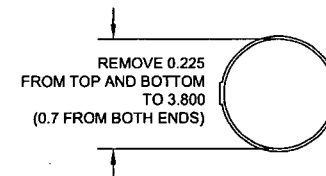
SECTION G-G
SCALE 5X



SECTION H-H
SCALE 5X

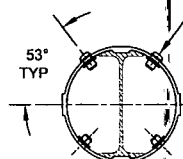


SECTION X-X
SCALE 5X

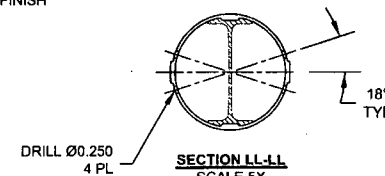


SECTION Y-Y
SCALE 5X

DRILL Ø0.297
INSTALL AELS-1032-130 INSERT
MS27039C1-09 SCREW
D3672-1 WASHER
AN960C10L WASHER
AFTER FINISH
4 PL



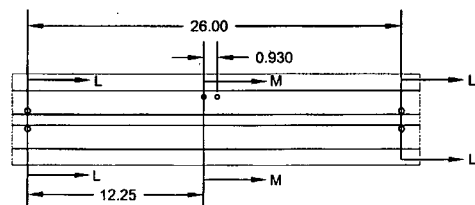
SECTION M-M
SCALE 5X



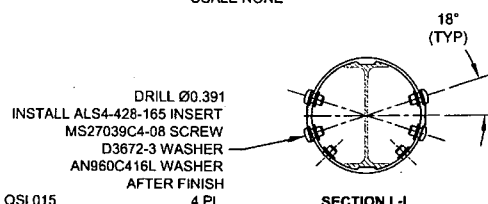
SECTION LL-LL
SCALE 5X

D3391-013 MID TUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
X	D3391-013	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
4	D3672-1	WASHER
4	D3672-3	WASHER
12	D3681-1	SPACER
24	AELS-1032-130	INSERT
4	ALS4-428-165	INSERT
4	AN960C10L	WASHER
4	AN960C416L	WASHER
4	MS27039C1-09	SCREW
4	MS27039C4-08	SCREW



DETAIL E
SCALE NONE



SECTION L-L
SCALE 5X

D3391-013 MID TUBE ASSEMBLY

- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
- 3) WELDING: PER DART QSI 004

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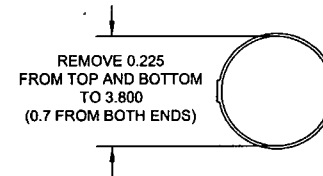
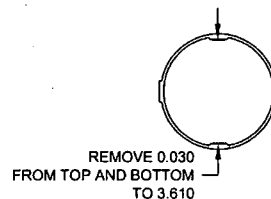
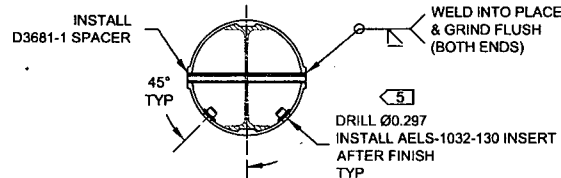
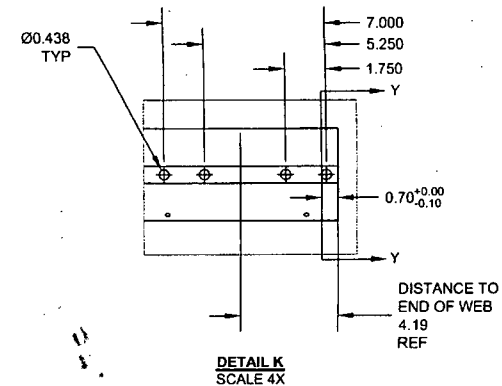
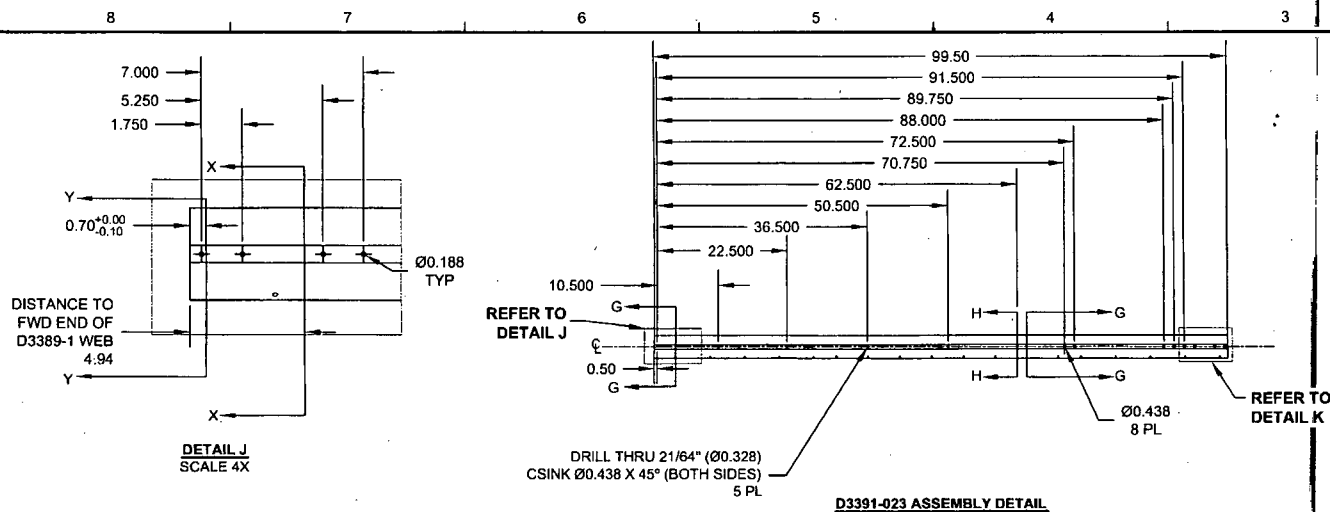
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D3391-023 MID TUBE ASSEMBLY PARTS LIST

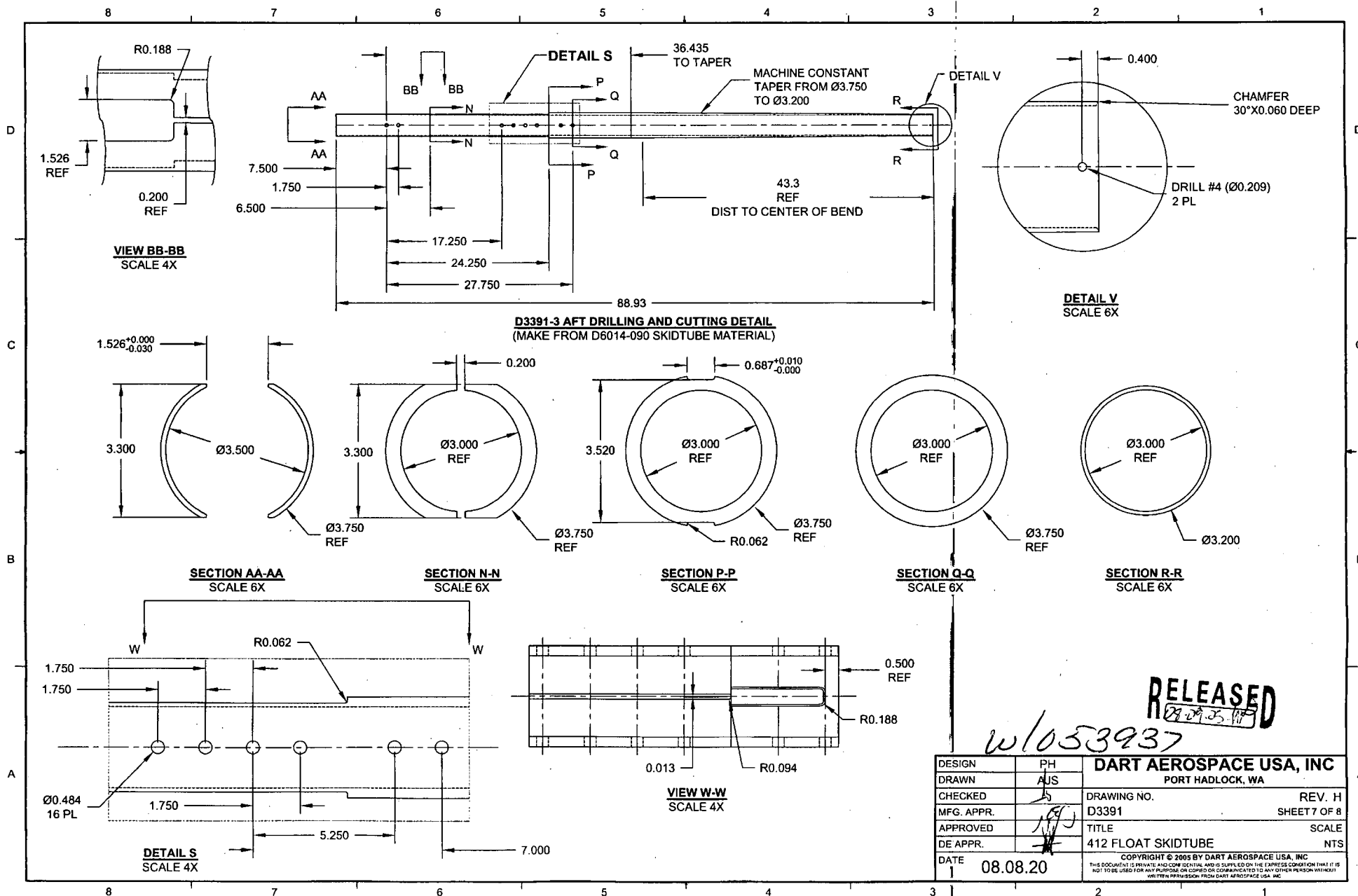
QTY -	PART NUMBER	DESCRIPTION
023		
X	D3391-023	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
5	D3681-1	SPACER
20	AELS-1032-130	INSERT

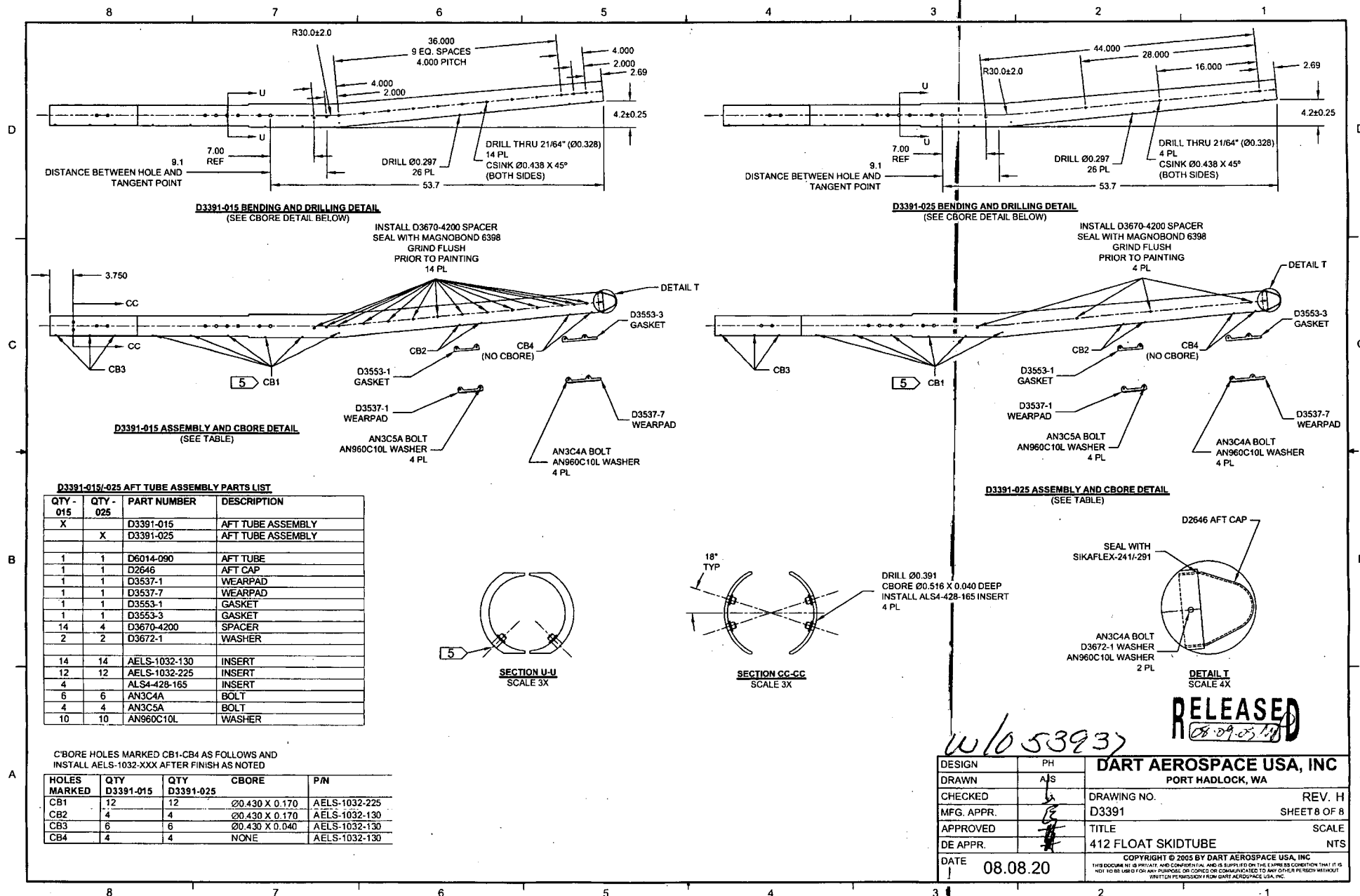
D3391-023 MID TUBE ASSEMBLY

- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
- 3) WELDING: PER DART QSI 004

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NO. 200

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 48035
Part number: D3391023
Description: Mid tube
Welding Process: Tig[☒] Mig[]
Base material: Aluminium
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual:
Penetration:

pass[☒] fail[]
pass[☒] fail[]

UNACCEPTABLE

Cracks:
Undercut:
Pin holes:
Overlap (cold lap)
Porosity (surface):
Coloration:

pass[☒] fail[]
pass[☒] fail[]
pass[☒] fail[]
pass[☒] fail[]
pass[☒] fail[]
pass[☒] fail[]

Qualifier Vol. 1

Date of Test Coupon 09-06-01

Welder Barclay Elliott

Date of Test Coupon 09-06-01

The above named individual is qualified in accordance with AWS D17.1.2001 to weld